

Date

Thursday, 06/11/2008 12:52:32 PM

User:

Chantal Lavoie

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 43232 : 12962

P.O. Number

Prsht Rev.

First Issue

Previous Run

This Issue

: 06/11/2008 S.O. No. :

: NC

: 11 : 34543 Type

: SMALL /MED FAB

Drawing Name

Part Number

: D36413

Drawing Number Project Number : D3641 REV B

: COVER

Drawing Revision

: N/A

Material

Due Date : 13/11/2008 Qty:

15 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:A

New Issue 07-07-20 JLM

Verified By:EC

ECN 1050 rev.b as per dwg 08-01-10 DD Est Rev:B

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Sheet 0.032"

1.0

M6061T6S032



Comment: Qtv.:

0.8244 sf(s)/Unit Total: 4.1218 sf(s)

M6061-T6 .032" THK sheet

Batch: 16959

2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev:_ Prog Rev:

128-11-7

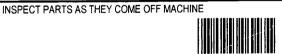


2-Deburr if necessary

3.0

QC2

HB8-11-7



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC



Comment: NC BRAKE

Form as per Dwg D3641-1



Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES				• .
DATE	STEP	PROCEDURE CHANGE By Date		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: <u>D3641-3</u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>08-11-13</u>
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR: 4	3232	W(ORK OR	DER NON-CONFORMANCE	E (NCR)			
	STEP	Description of NC	Description of NC Corrective Action Section B		Verificatio		Approval	Approval
DATE STE		Section A	Initial Action Description Sign & Chief Eng Date		Section C	Chief Eng	QC Inspector	
811.07	5	400h 3 pcs for D3641-4 see who 43233 wrong M2+ " used for -4 on wy = uo more wz+1		Used on w/0 43233 to complete shipment	98/1/12	SA		
		wrong metil used for -4 on wy = 40 more metil	rosiw2	,		08/11/19	Posius	Nou.12
		U	-					
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NOTE: Date & initial all entries

Dāte: Thursday, 06/11/2008 12:52:32 PM User;: , Chantal Lavoie **Process Sheet Drawing Name: COVER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 43232 Part Number: D36413 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 7.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then \$tock Location: FINAL INSPECTION/W/O RELEASE QC21 10.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion u 08,11.3

Dart Aerospa	ce	Lt	d
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W/O:			WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	NCR: Ye	s No DO	QA:	🖺 Date: _	
	Re	solution:	Disposition	:	QA: N/C	Closed: _		Date: _	
NCR:		-	WORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B Sign	۱& ∣ _{Sec}	ication etion C	Approval Chief Eng	Approval QC Inspector
			on and	0.1101 2.119					
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NOTE: Date & initial all entries

8 D **B** 4.78 3.82 3.64 GRAIN DIRECTION 1.14 0.96 0.50 0 Ø0.191 (3 PLACES) 0 0.90 22.42 С **BEND LINES D3641-3F FLAT PATTERN** 90°±1° (TYP) 6708/11/06 2.50 1.00 (TYP) - R0.06 (TYP) 0.25 D3641-3 COVER (REPLACES GENEVA P/N G10606-5) D3641-4 OPPOSITE (REPLACES GENEVA P/N G10606-4) DART AEROSPACE USA, INC. PORT HADLOCK, WA DESIGN NOTES:
1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.032)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWN CHECKED DRAWING NO. PW REV. B D3641 MFG. APPR SHEET 2 OF 2 TITLE APPROVED SCALE 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX COVER DE APPR.

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1:3

07.10.16

2

DATE

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER 7) WEIGHT: 0.36 lbs

7

DART AEROSPACE	I TD		Work Order:	43232
DANI ALKOOI MOL	20			
Description:	Cover		Part Number:	D3641-3
				Dana 4 of 4
Inspection Dwg:	. Rev:	1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
8 191	1005 - 2001	1198				
.50	th .030	502,		· .		
4.78	4030	4,777				
,84	1/036	,834			-	
.90	Y030	,909				
12.42	1/2 .030	12.43			· · · · · · · · · · · · · · · · · · ·	
64.66	× .030	27.42				
24.00	4/ 1030	24,00				
24.84	7- 1030	24.839				
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Measu	red by:	IR .	Audited by:		Prototype Approval:	UIAn
	Date:	8-11-7	Date:	108-11-07	Date:	
Rev	Date	Change			Revised by	Approved
1464	Dare	Nowleave			KJ/JLM	

